

4TECH® 9KF23500 HI

Polycarbonate + PBT
4Plas

Message:

4TECH 9KF23500 HI is a Standard Flow Halogen Free FR-V0 Heat Stabilised, Impact Modified PBT / Polycarbonate Blend

General Information			
Additive	Impact modifier		
	heat stabilizer		
Features	Impact modification		
	Thermal Stability		
	Halogen-free		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.34	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (270°C/2.16 kg)	60	g/10 min	ISO 1133
Water Absorption ¹ (Equilibrium, 23°C, 50% RH)	0.10	%	ISO 62
Moisture Content	< 1000	ppm	ISO 960
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2100	MPa	ISO 527-2/5
Tensile Stress (Break, 23°C)	45.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	20	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180/1A
-20°C	8.0	kJ/m ²	ISO 180/1A
23°C	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	No Break		ISO 180/1U
23°C	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	130	°C	ISO 75-2/B
1.8 MPa, not annealed	60.0	°C	ISO 75-2/A
Vicat Softening Temperature	160	°C	ISO 306/B
Melting Temperature	220 - 230	°C	DSC
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	IEC 60093

Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Comparative Tracking Index	250	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	V-0		UL 94
3.20 mm	V-0		UL 94
Glow Wire Ignition Temperature (2.00 mm)	960	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Processing (Melt) Temp	230 - 270	°C	
Mold Temperature	50.0 - 110	°C	
Injection Rate	Moderate-Fast		
Holding Pressure	40.0 - 80.0	MPa	
Screw Speed	300	rpm	
Injection instructions			
Feed Throat Temperature: 50 - 70 °C Back Pressure: Low			
NOTE			
1.	24 Hrs		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

